



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5629-041
Job Sheet 181809



Part No: D5629-041

Job Qty: 8 ea

Part Name: End Cap Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5629 REV.A IPP REV:A 18.04.10 NEW ISSUE DD VERF:DP IPP REV:B 18/08/03 AS PER DWG REV.B JFS
VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	8 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Machining-4		
105	CNC Vertical Machining	8 pcs	8/17/18	8/17/18	0.00	10.67	HAAS 5 Axis		
110	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC2-3		
112	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC8 Machining-5		
114	HandFinish	8 pcs	8/17/18	8/17/18	0.00	0.00	HandFinish1		
116	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC7-3		
118	Small Fab	8 pcs	8/17/18	8/17/18	0.00	0.80	Small Fab-9		
120	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC5		
130	Packaging	8 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-2		
140	QC21-SA	8 Ea	8/17/18	8/17/18	0.00	0.00	QC21		

Part Op 105 - -Machine as per folio FC023 -Deburr
Descriptions: 118 - INSTALL NUT PLATE AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.500X03.500	6061-T6 Bar 2.50 X 3.50	1.8000 ft (.225 ea)	100-Start up Operation	S109 850
CCR264SS-3-04	Nutplate Rivet	64 (8 ea)	118-Small Fab	5014217 5108574
MS21076-3	Anchor Nut	32 Ea (4 ea)	118-Small Fab	M133922-300 24X M134502-301 8X

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	M6061T6B2.500X03.500	2	6	0
118-Small Fab	CCR264SS-3-04	64	0	0
	MS21076-3	32	89	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ ing ☐ ilier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval							
Description Work Order Deviation											
Root Cause <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 50%;"> OTHER : ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	OTHER : ☐	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> <td style="width: 50%;"></td> </tr> </table>		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
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Date: 09/13/18

Instructions: Various ST's

Exp Date: _____

Inspector: _____

Revision: B

Serial No/Batch: S109857

Job No: 181809

Part: D5629 - 041

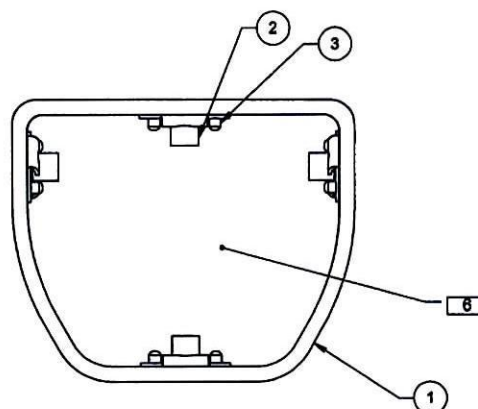
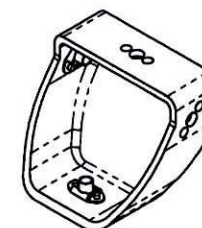
Container No: S109857

DART AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 832-8200
Email: sales@dartaero.com
www.dartaerospace.com

ITEM	QTY	P/N	DESCRIPTION
	X	D5629-041	END CAP ASSY
1	1	D5629-1	END CAP
2	4	MS21076-3	NUT PLATE
3	8	CCR264SS-03-04	NUTPLATE RIVET, CHERRY

△ B



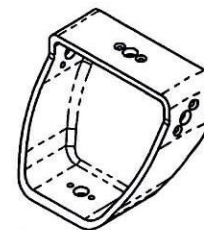
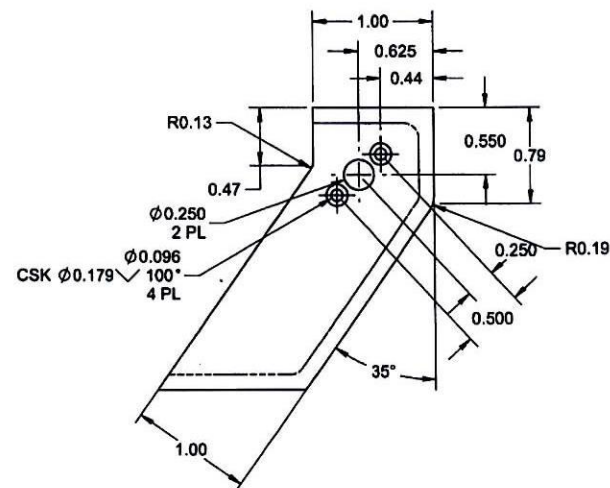
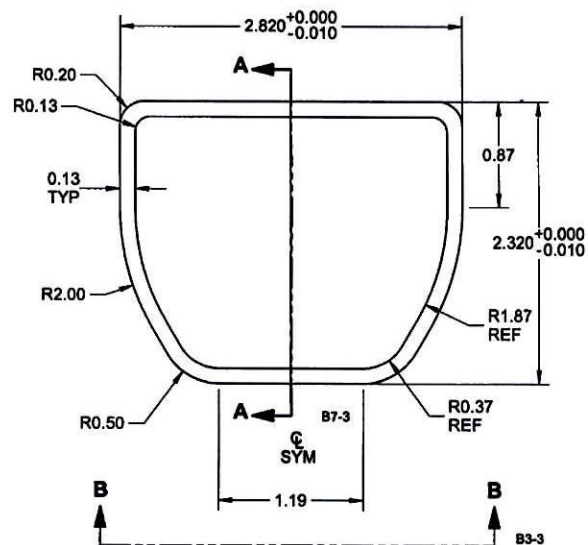
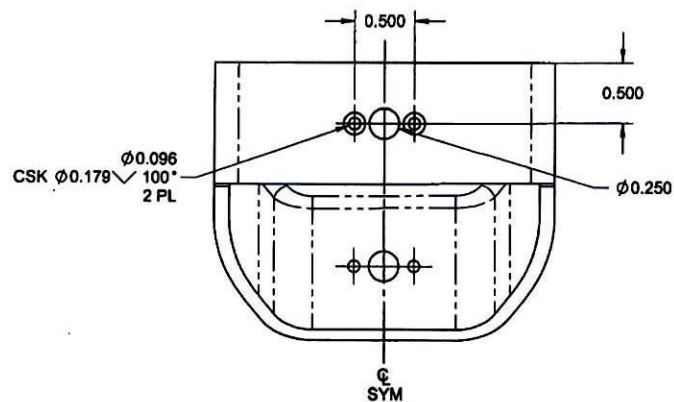
D5629-041 END CAP ASSY

NOTES:
 1) MATERIAL: NONE
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 7) WEIGHT: 0.19 lbs

RELEASED
 2018 JUL 30 NO
 ECH R-749

APPROVED

B	CCR264SS-03-04 WAS MS20426AD3-5 (ZN D6-1)	VS	18.05.23
A	NEW ISSUE	VS	18.03.20
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5629	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	END CAP	NTS
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D5629-1 END CAP

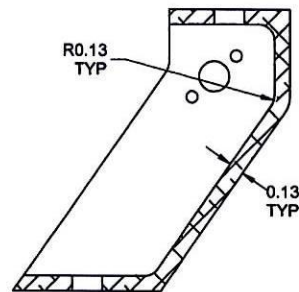
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

RELEASED
2018 JUL 30 No

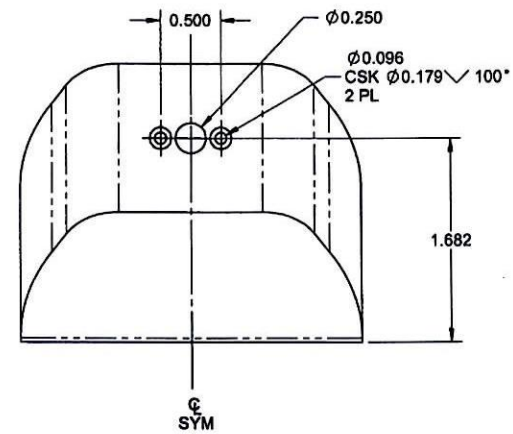
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DESIGN	VS	DART AEROSPACE LTD	
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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5629	SHEET 2 OF 3
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SECTION A-A

B6-2



VIEW B-B

A6-2

RELEASED

2018 JUL 30 No

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